

Work Order ID 54521

December 10, 2009 3:18:27 PM



Page 1

Item ID: D3654-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/12/2009 Start Qty: 4.00

Required Date: 11/12/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: PLDate: 09/12/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3654	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3654 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessaryB 9-12-11(9)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-12-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 807/12/11(x6) P12 ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/12/11	120	Took Qty 11 For QC inspection template	S	09/12/11	41		S 02/12/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54521

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Item ID: D3654-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 11/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/12/11

09/12/14

11/09/12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 10, 2009 3:18:30 PM

Work Order ID: 54521

Parent Item: D3654-1

Parent Item Name: Doubler



Comments:

Start Date: 10/12/2009

Required Date: 11/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	395.6457	1.4737	2.6		
304/316 Sheet .063												

B 9-12-11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

395.6456737

106860

16.018

111924

25.1689737

112442

29.8899

112567

0.2973

112885

4.2715

113295

320

113295

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 54521
Description: Double		Part Number: D3654-1
Inspection Dwg: D3654-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

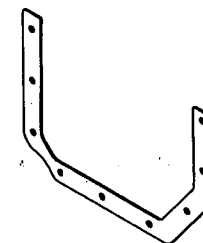
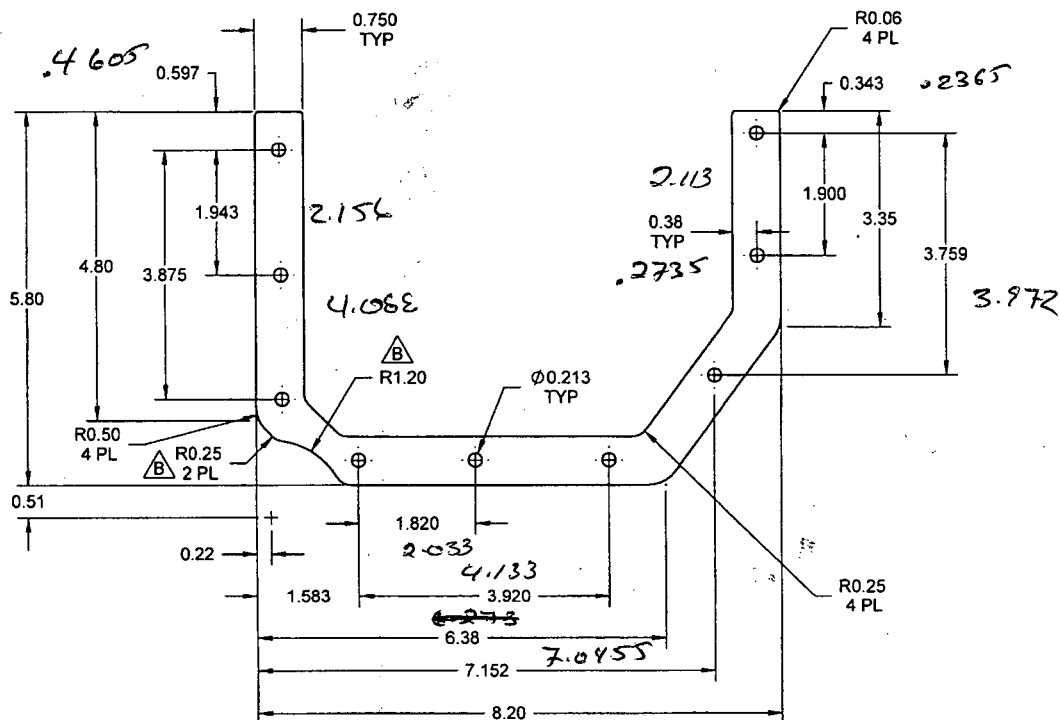
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .213	+ .005 - .001	.214	✓			
.750	± .010	.754	✗			
.597	± .010	.595	✗			
1.943	± .010	1.945	✗			
3.875	± .010	3.870	✗			
4.80	± .030	4.80	✗			
5.86	± .030	5.793	✗			
2.2	± .010					
1.583	± .010	1.582	✓			
1.820	± .010	1.822	✗			
3.920	± .010	3.918	✗			
6.38	± .030	6.38	✗			
7.152	± .010	7.159	✗			
8.20	± .030	8.204	✗			
.343	± .010	.343	✗			
1.900	± .010	1.900	✗			
3.35	± .030	3.35	✗			
3.754	± .010	3.754	✗			
.38	± .030	.38	✗			
.063	± .010	.056	✗			

Measured by: JB
Date: 9-12-11

Audited by: S
Date: 09/12/11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHO
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT
WORK
NO. 5452

0. 54/5-21




PL 09-1210

D3654-1 DOUBLER

RELEASE
08-09-16

NOTES:

- NOTES
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER AMS 5513/5524 (REF. DART SPEC. M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.03 lbs

B	ADD R1.20 & R0.25 (ZN C6); MATERIAL NOTE AMS 5513/5524 WAS MIL-S-5019 (ZN A8); REFORMATTED DRAWING TO CURRENT STANDARD		RF	08.09.11
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3654	SHEET 1 OF	
APPROVED		TITLE	SCALE	
DE APPR.		DOUBLER	NT	
DATE	08.09.11			
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